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**Lo**

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(54) **LOW LOSS PASSIVE OPTICAL HUB FOR USE IN THE PLASTIC OPTICAL FIBER NETWORKS**

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USPC ..... 385/14, 17, 24, 46  
See application file for complete search history.

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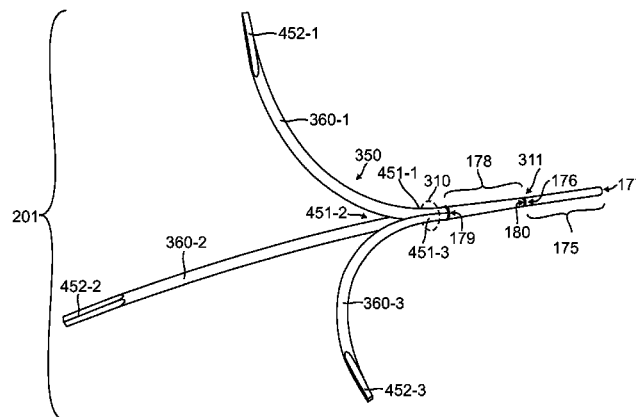
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(57) **ABSTRACT**

A node for a low loss passive optical hub is provided. The low loss passive optical hub includes a 1:N-split fiber and a plastic-optical fiber. The 1:N-split fiber has a fused-fractional end and N second-fractional ends. The 1:N-split fiber is formed from N sub-fibers. The N sub-fibers each have a first-fractional end and a second-fractional end. The N first-fractional ends are fused to form the fused-fractional end. The plastic-optical fiber has a first end and a second end. The first end of the plastic-optical fiber is optically coupled to the fused-fractional end of the 1:N-split fiber.

**14 Claims, 12 Drawing Sheets**



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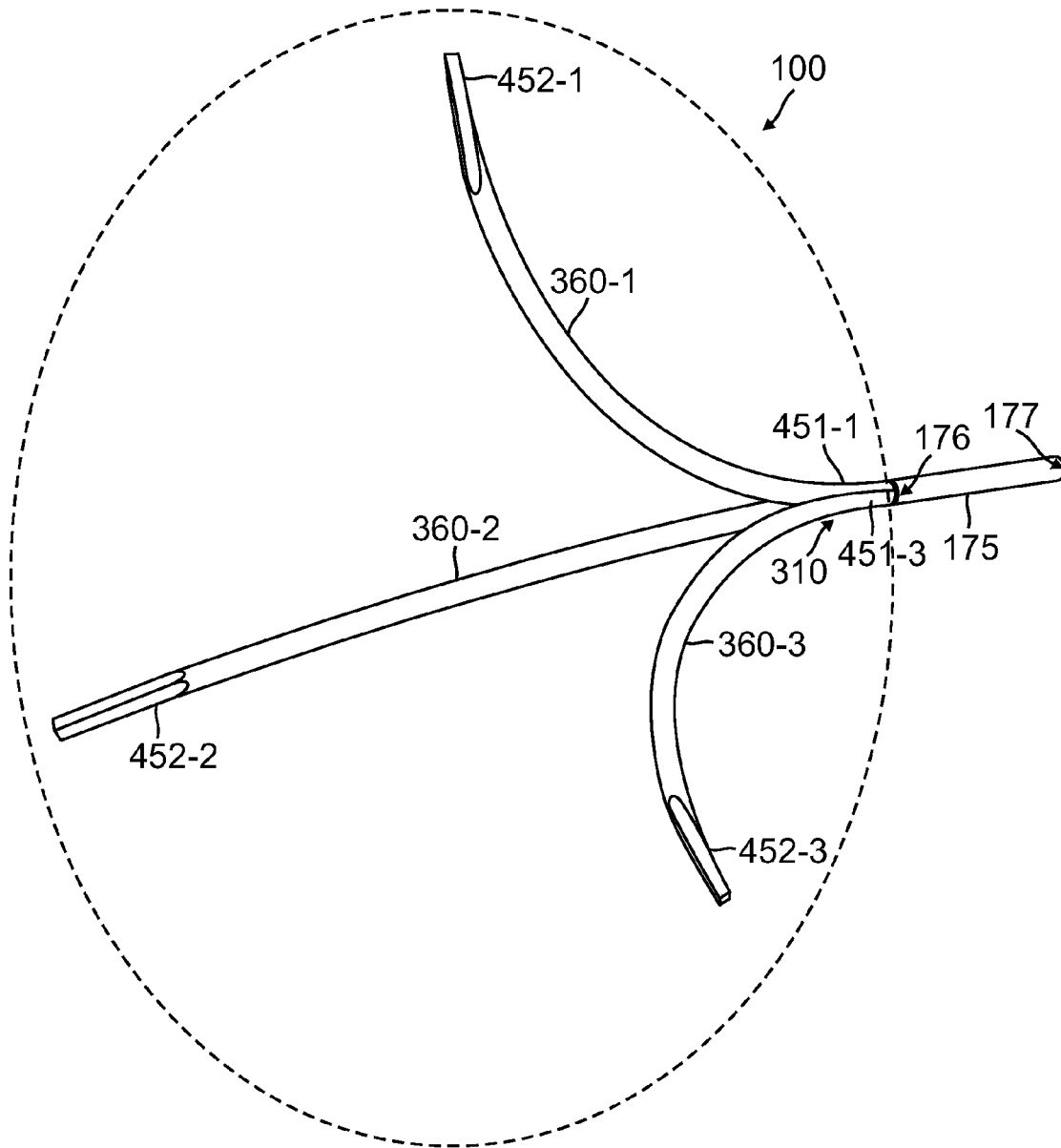
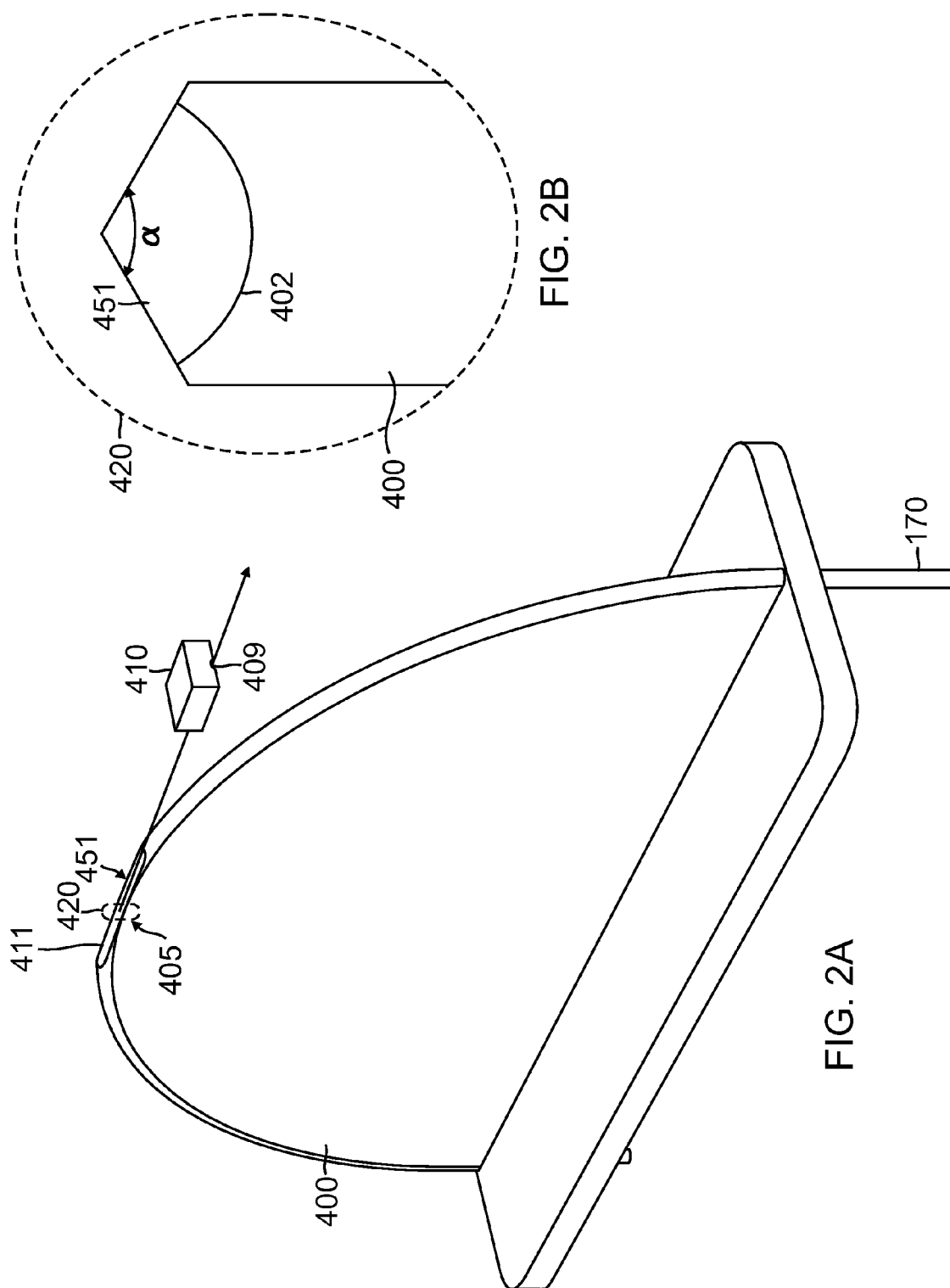


FIG. 1



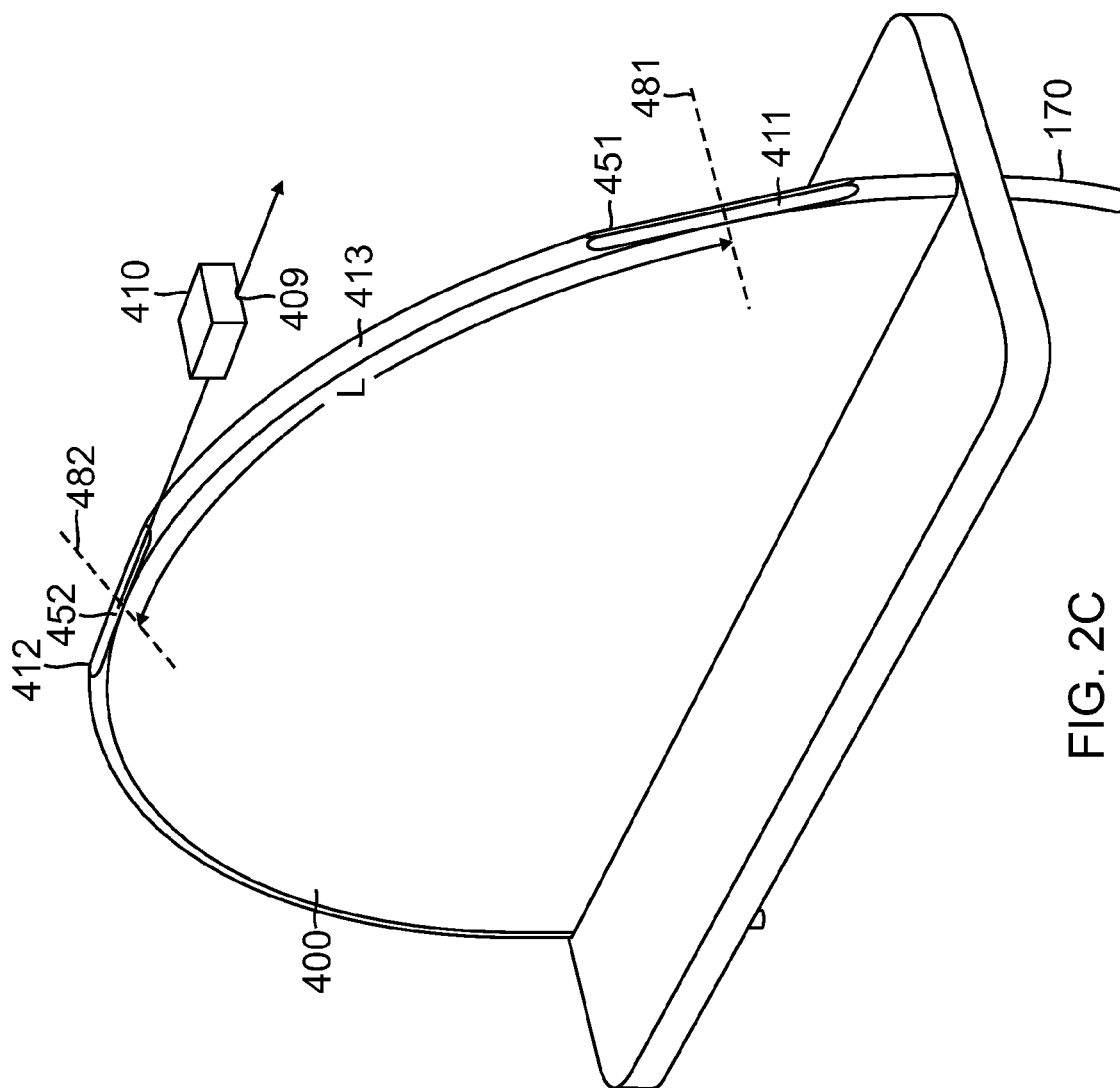


FIG. 2C

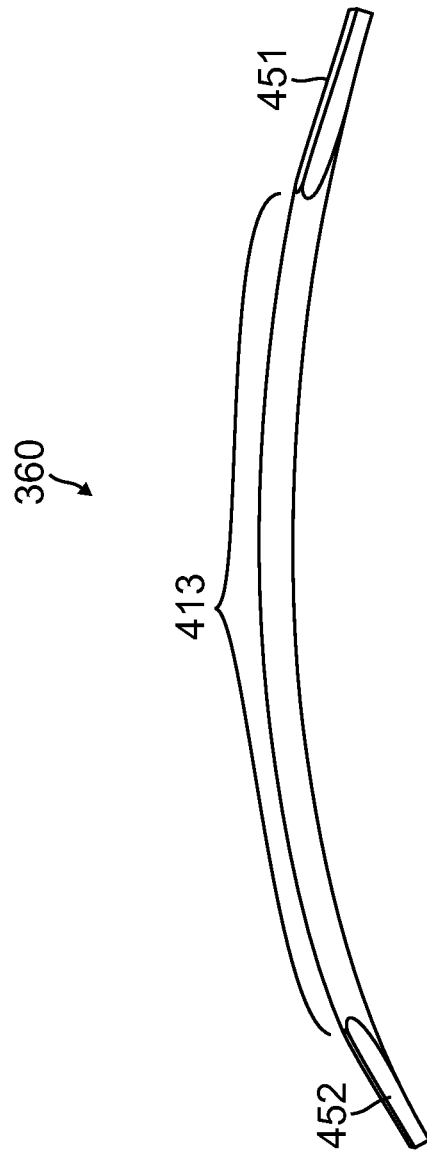


FIG. 3

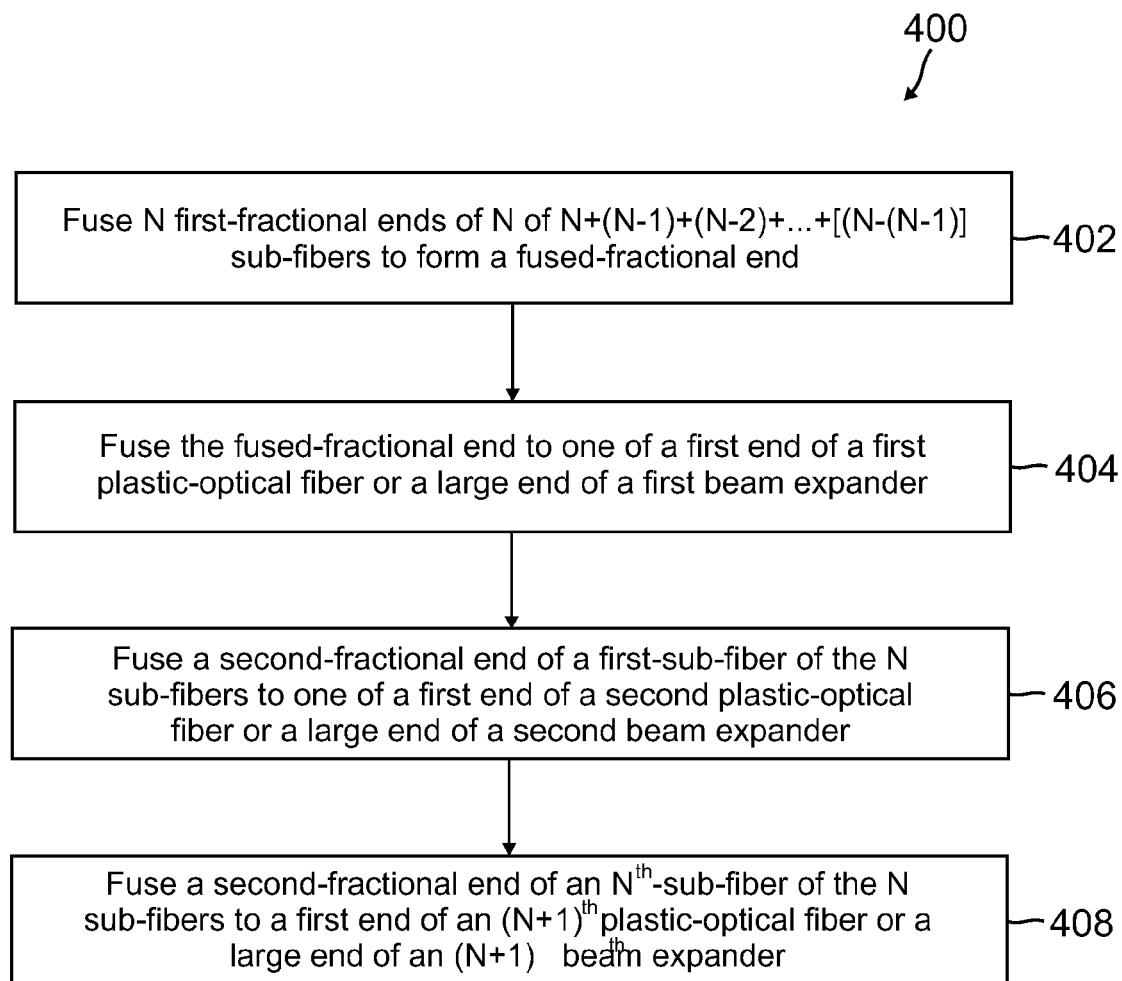


FIG. 4

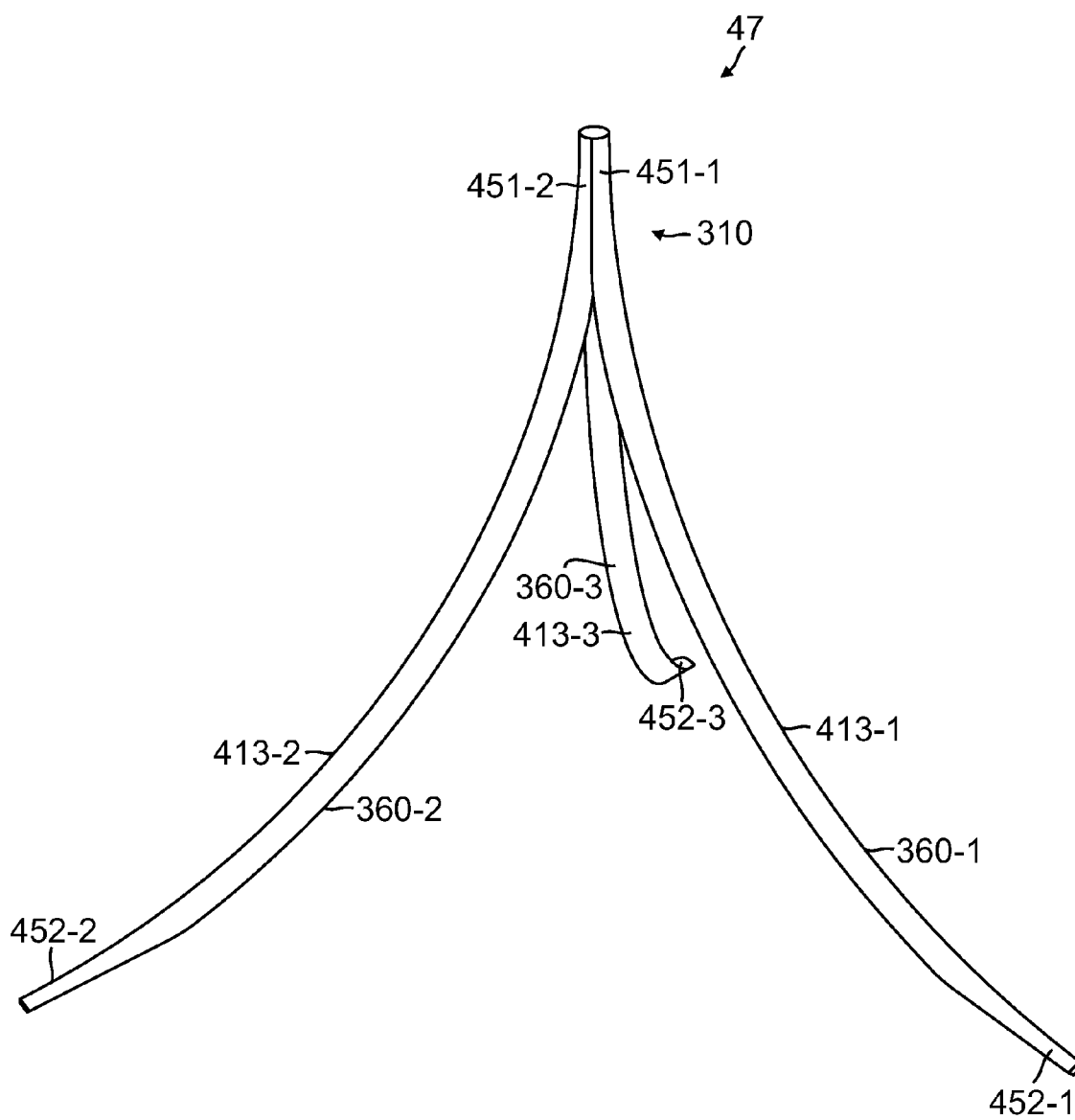


FIG. 5

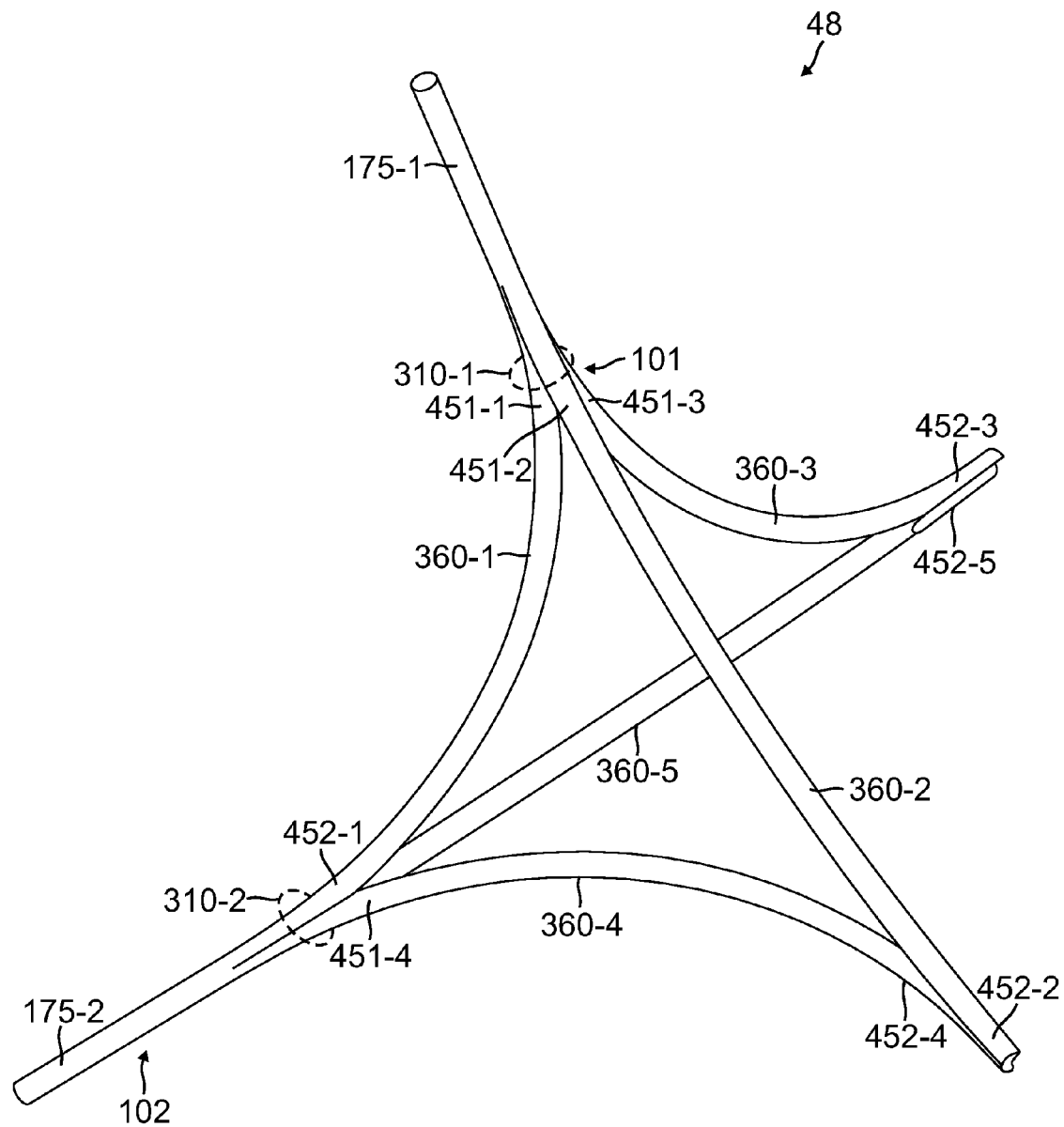


FIG. 6

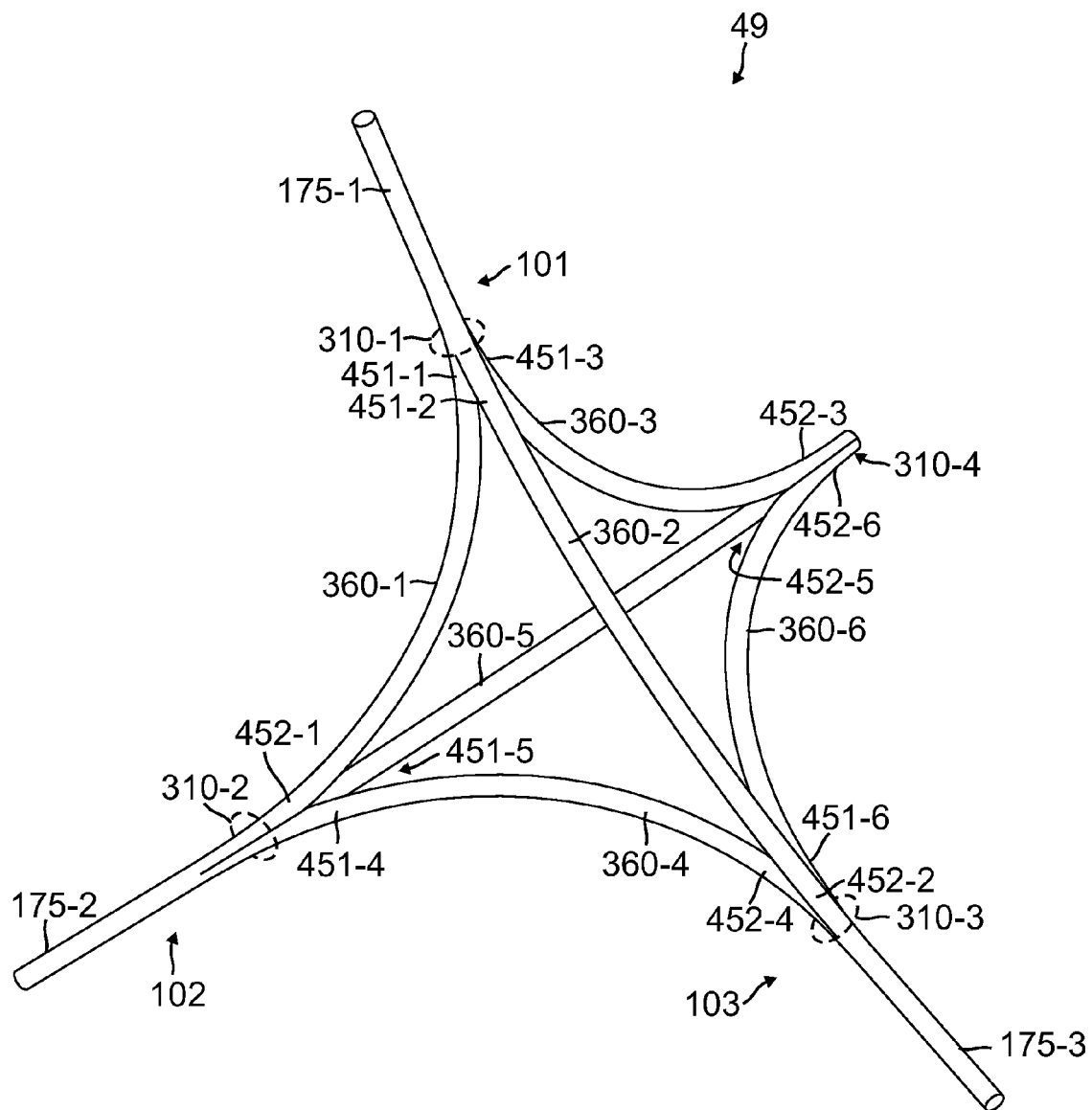


FIG. 7

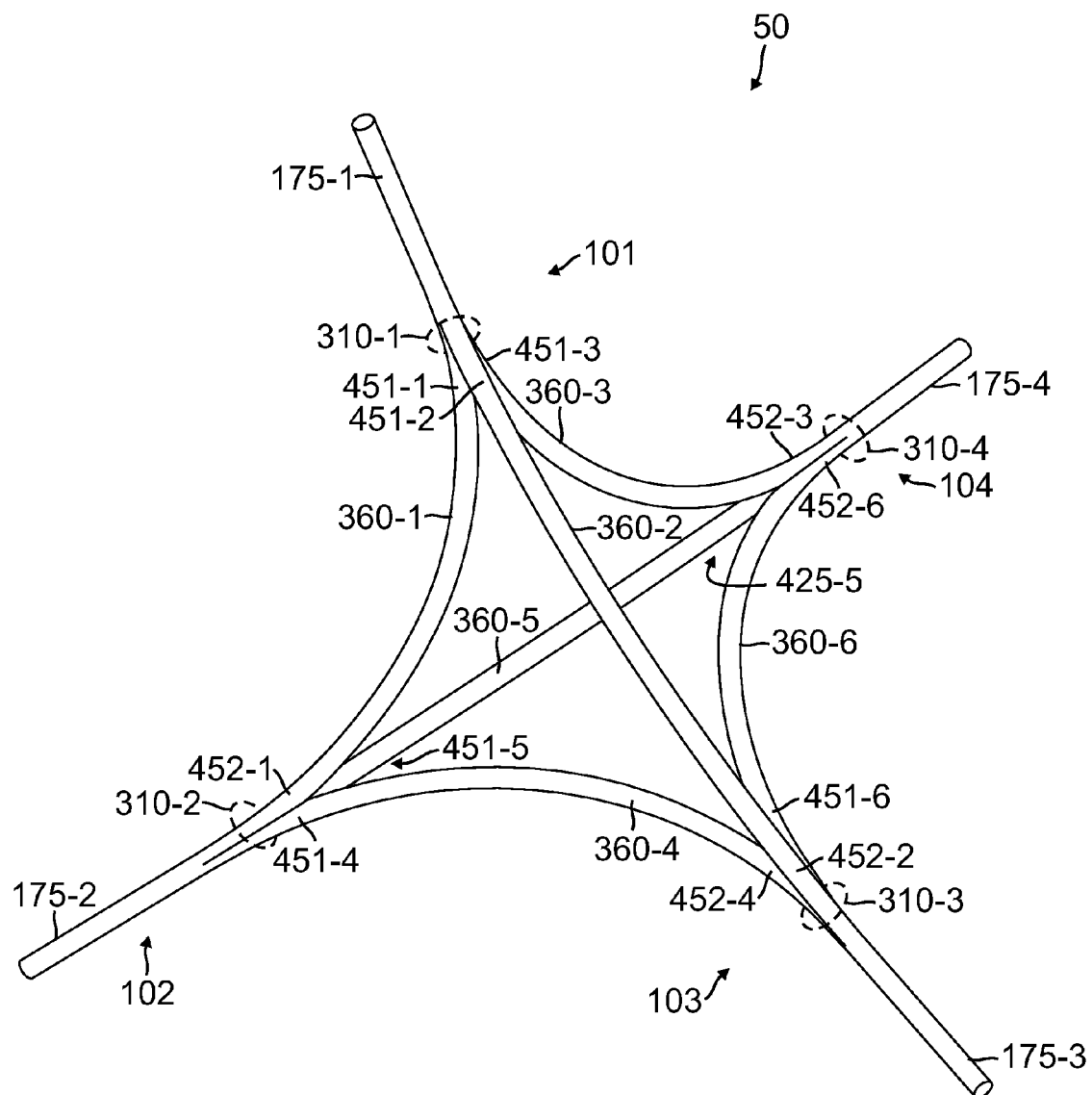


FIG. 8

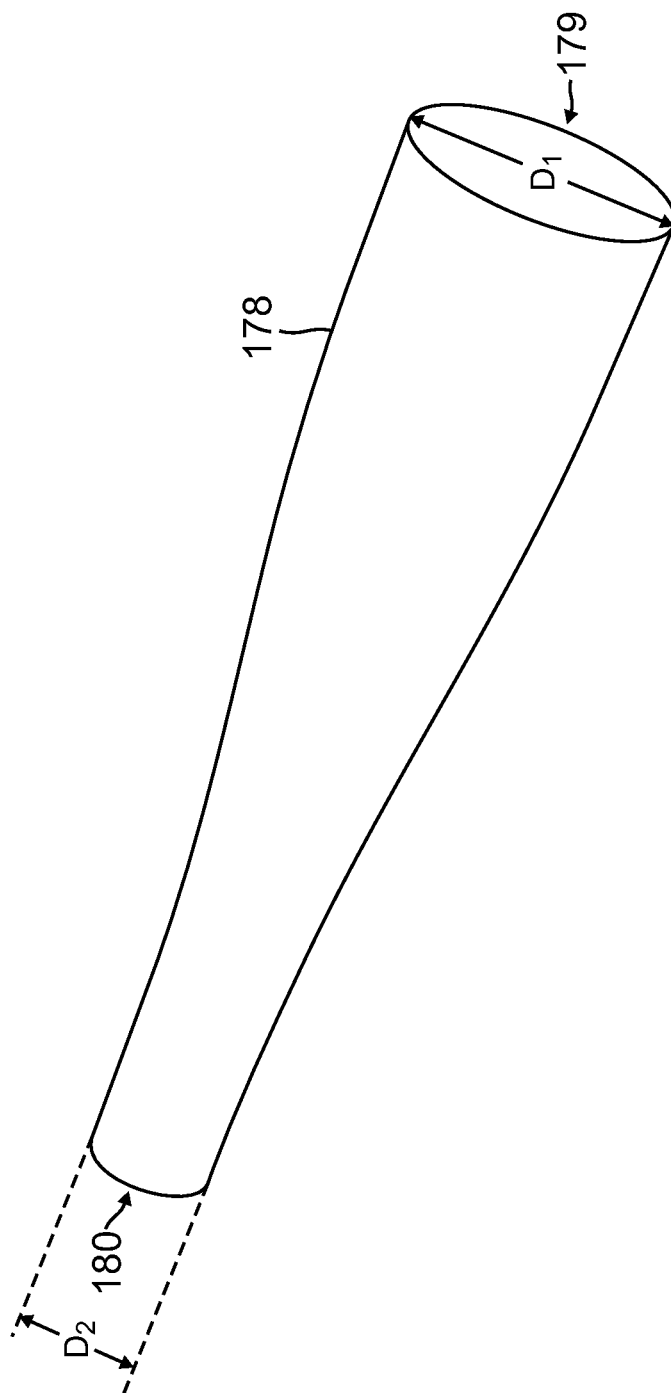


FIG. 9

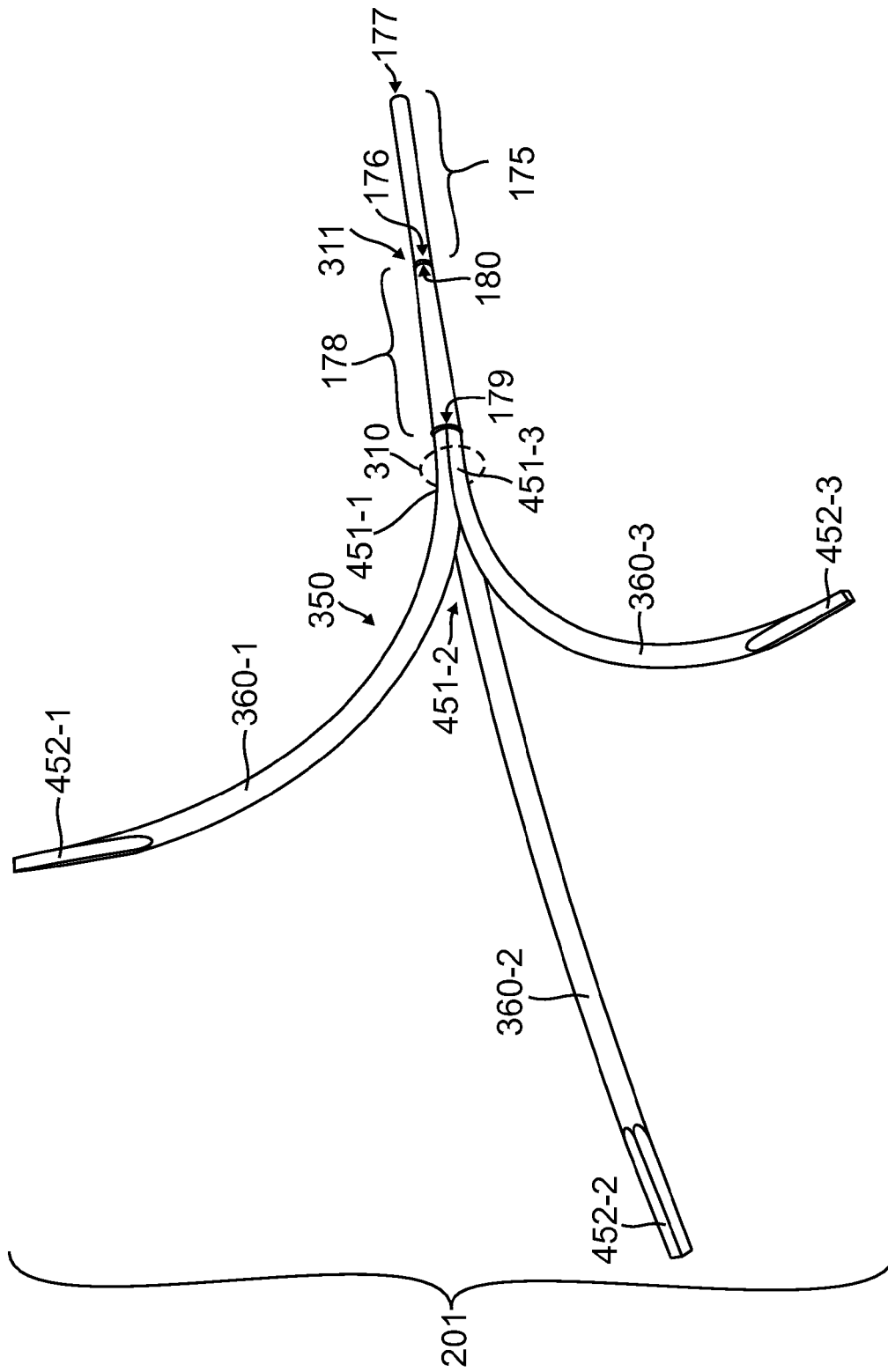


FIG. 10

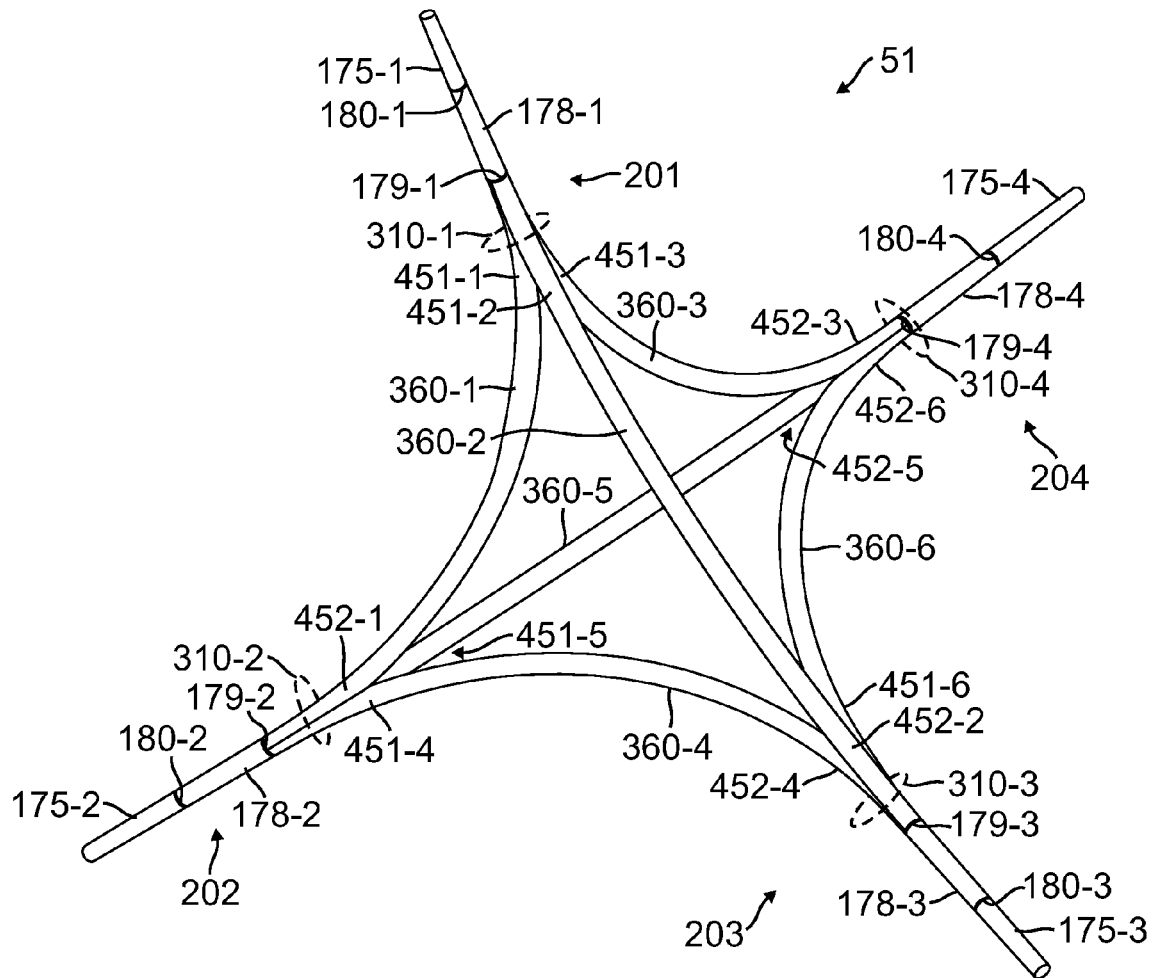


FIG. 11

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# LOW LOSS PASSIVE OPTICAL HUB FOR USE IN THE PLASTIC OPTICAL FIBER NETWORKS

## BACKGROUND

Plastic Optical Fiber (POF) is gaining popularity in avionic lower bandwidth (10-50 mbps) networks since plastic-optical fibers are low cost, light weight, and easy to install and to maintain. POF has inherently higher loss than glass fibers so the link budget is an important factor in the acceptance of POF into aircraft. A Passive Optical Hub (POH) would be an ideal component to enable plastic-optical fiber in a conventional bus network. However, unlike the copper data bus, the currently available passive optical hubs suffer loss that limits the network size (e.g., the number of nodes) and the distance covered by the hub. Current bus network passive optical hub designs incorporate either a mirror or a return loop. Both the mirror and return loop suffer from return loss, reflectivity losses, dispersion, and uniformity losses.

For the reasons stated above and for other reasons stated below which will become apparent to those skilled in the art upon reading and understanding the specification, there is a need in the art for improved passive optical hubs.

## SUMMARY

The embodiments of the present invention provide a passive optical hub made from plastic fibers (a plastic POH) and methods for making the plastic passive optical hub and will be understood by reading and studying the following specification.

The present application relates to a node for a low loss passive optical hub. The low loss passive optical hub includes a 1:N-split fiber and a plastic-optical fiber. The 1:N-split fiber has a fused-fractional end and N second-fractional ends. The 1:N-split fiber is formed from N sub-fibers. The N sub-fibers each have a first-fractional end and a second-fractional end. The N first-fractional ends are fused to form the fused-fractional end. The plastic-optical fiber has a first end and a second end. The first end of the plastic-optical fiber is optically coupled to the fused-fractional end of the 1:N-split fiber.

## DRAWINGS

Embodiments of the present invention can be more easily understood and further advantages and uses thereof more readily apparent, when considered in view of the description of the preferred embodiments and the following figures in which:

FIG. 1 illustrates an embodiment of node for a low loss passive optical hub in accordance with the present invention;

FIG. 2A illustrates a fiber-shaving apparatus with a fiber shaved to form a first-fractional end of a sub-fiber in accordance with the present invention;

FIG. 2B illustrates a cross-section view of the first-fractional end of the sub-fiber in the fiber-shaving apparatus of FIG. 2A in accordance with the present invention;

FIG. 2C illustrates the fiber-shaving apparatus of FIG. 2A with a fiber shaved to form a first-fractional end and a second-fractional end of a sub-fiber in accordance with the present invention;

FIG. 3 illustrates a sub-fiber in accordance with the present invention;

FIG. 4 is a flow diagram of an embodiment of a method of forming an (N+1)-way passive optical hub for use in a plastic optical fiber network;

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FIG. 5 illustrates three first-fractional ends of three respective sub-fibers fused to form a fused-fractional end in accordance with the present invention;

FIG. 6 illustrates a partially formed plastic optical hub in which two fused-fractional ends are fused to two respective plastic-optical fibers in accordance with the present invention;

FIG. 7 illustrates a partially formed plastic optical hub in which three fused-fractional ends are fused to three respective plastic-optical fibers in accordance with the present invention;

FIG. 8 illustrates the plastic optical hub in accordance with the present invention;

FIG. 9 illustrates a beam expander in accordance with the present invention;

FIG. 10 illustrates an embodiment of a node for a low loss passive optical hub including the beam expander of FIG. 9 in accordance with the present invention; and

FIG. 11 illustrates an embodiment of a low loss passive optical hub including the beam expander of FIG. 9 in accordance with the present invention.

In accordance with common practice, the various described features are not drawn to scale but are drawn to emphasize features relevant to the present invention. Reference characters denote like elements throughout figures and text.

## DETAILED DESCRIPTION

In the following detailed description, reference is made to the accompanying drawings that form a part hereof, and in which is shown by way of specific illustrative embodiments in which the invention may be practiced. These embodiments are described in sufficient detail to enable those skilled in the art to practice the invention, and it is to be understood that other embodiments may be utilized and that logical, mechanical and optical changes may be made without departing from the scope of the present invention. The following detailed description is, therefore, not to be taken in a limiting sense.

Instead of bundling all ports and fusing them together to combine all ports into one and reflect the light wave back onto these ports, as is done in prior art passive optical hubs (POHs), the embodiments of POHs described herein physically split a plastic-optical fiber and connect the split sections into a peer to peer bus network. The POHs described herein are formed from plastic optical fibers.

FIG. 1 illustrates an embodiment of node **100** for a low loss passive optical hub in accordance with the present invention. The node **100** includes a 1:N-split fiber **350** and a plastic-optical fiber **175**. The plastic-optical fiber **175** has a first end **176** and a second end **177**.

The 1:N-split fiber **350** is formed from N sub-fibers **360(1-N)**. The N sub-fibers **360(1-N)** each have a first-fractional end **451** and a second-fractional end **452**. The N first-fractional ends **451** are fused to form a fused-fractional end **310**. In one implementation of this embodiment, N equals 2. In another implementation of this embodiment, N is greater than 3.

As shown in FIG. 1, N equals 3 and the 1:N-split fiber is a 1:3-split fiber **350**. The node **100** is an optical node **100** to split optical power propagating from the optical fiber **175** to the 1:3-split fiber **350** into 3 approximately equal amounts. The 1:3-split fiber is formed from three sub-fibers represented generally at **360(1-3)** in FIG. 1. The first sub-fiber **360-1** has a first-fractional end **451-1** and a second-fractional end **452-1**. The third-sub-fiber **360-3** has a first-fractional end **451-1** and a second-fractional end **452-1**. The second-sub-fiber **360-2** has a first-fractional end **451-2**, which is obscured behind the

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first-fractional ends **451-1** and **451-2** in FIG. 1, and a second-fractional end **452-2**. The three (3) first-fractional ends **451 (1-3)** are fused to form a fused-fractional end **310**. The 1:3-split fiber **350** has the fused-fractional end **310** and the loose first-fractional ends **452(1-3)**. The first end **176** of the plastic-optical fiber **175** is optically coupled to the fused-fractional end **310** of the 1:N-split fiber **350**, either directly or through a beam expander, which is described in detail below.

If the first-fractional ends **451(1-3)** have equal cross-sectional areas then the first-fractional ends **451(1-3)** of the sub-fibers **360(1-3)** each subtend a 120 degree angle. If the first-fractional ends **451(1-3)** do not have equal cross-sectional areas then the first-fractional ends **451(1-3)** of the sub-fibers **360(1-3)** can have a cross-sectional proportions that sum to 100%. For example, the first-fractional ends **451-1**, **451-2**, and **451-3** have exemplary relative percentages of cross-sections of: 60%/20%/20%; 40%/30%/30%; or 50%/30%/20%. If the first-fractional ends **451-1**, **451-2**, and **451-3** can have exemplary relative percentages of cross-sections of: 50%/30%/20%, then the first first-fractional end **451-1** subtends an angle of 180 degrees, the second first-fractional end **451-2** subtends an angle of 108 degrees, and the third first-fractional end **451-3** subtends an angle of 72. The subtended angles sum to 360 degrees.

The relative percentages of cross-sections of the first-fractional ends **451(1-3)** are selected based on the design of a POH, the location of the node **100** in the POH, and the location of the POH in a network of POH the POH described herein.

In one implementation of this embodiment, the three sub-fibers **360(1-3)** are fabricated by mechanically shaving a plastic-optical fiber **176** into three sub-fibers **360(1-3)** having the desired proportion of cross-sectional areas. FIG. 2A illustrates a fiber-shaving apparatus **400** with a fiber **170** shaved to form a first-fractional end **451** of a sub-fiber **360** (FIG. 1) in accordance with the present invention. FIG. 2B illustrates a cross-section view of the first-fractional end **451** of the sub-fiber **170** formed by the fiber-shaving apparatus **400** of FIG. 2A in accordance with the present invention. The circle **420** in FIG. 2A is shown expanded in cross-section in FIG. 2B. FIG. 2C illustrates the fiber-shaving apparatus **400** of FIG. 2A with a fiber **170** shaved to form a first-fractional end **451** and a second-fractional end **452** of a sub-fiber **360** in accordance with the present invention. FIG. 3 illustrates a sub-fiber **360** in accordance with the present invention. The sub-fiber **360** was formed by the shaving process indicated by FIGS. 2A-2C.

As shown in FIG. 2A, a plastic-optical fiber **170** is positioned in groove **402** (FIG. 2B) in the fiber-shaving apparatus **400**. A shaving element **410** has a V-shaped-indent **409**. The angle of the V in the V-shaped-indent **409** is the angle of desired subtended angle in the first-fractional end **451** and the second-fractional end **452**. As shown in FIG. 2B, the first-fractional end **451** subtends the angle  $\alpha$ . To form the first-fractional end **451** shown in FIG. 2B, the angle of the V in the V-shaped-indent **409** is the angle  $\alpha$ .

The shaving element **410** is run over the plastic-optical fiber **170** along a first portion **411** that is at the top of the curve of the fiber-shaving apparatus **400** represented generally at **405**. A first portion **411** of the plastic-optical fiber **170** is thus shaved and has a cross sectional shape subtending the angle  $\alpha$  as shown in FIG. 1B. In one implementation of this embodiment, the plastic-optical fiber **170** is held still and the shaving element **410** is moved along the plastic-optical fiber **170** to shave a first portion **411** of the plastic-optical fiber **170**. In another implementation of this embodiment, the shaving element **410** is placed against the plastic-optical fiber **170** at the top **405** of the curve of the fiber-shaving apparatus **400** and the

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plastic-optical fiber **170** is pulled so the plastic-optical fiber **170** moves under the fiber-shaving apparatus **400** for a length equal to the length of the first portion **411**.

After the first-fractional end **451** is shaved the plastic-optical fiber **170** is pulled along the fiber-shaving apparatus **400** (without the shaving element **410** touching the plastic-optical fiber **170**) until a section **412** of the plastic-optical fiber **170** located a length L from the center of the first portion **411** (e.g., from the dashed line **481** shown in FIG. 2C) is at the top **405** of the curve of the fiber-shaving apparatus **400**. The shaving element **410** is again run over the plastic-optical fiber **170** along the second portion **412** that is now at the top **405** of the curve of the fiber-shaving apparatus **400**.

The plastic-optical fiber **170** is removed from the fiber-shaving apparatus **400** and the plastic-optical fiber **107** is cut at the midsection represented generally at **481** of the first portion **411** and is cut at the midsection represented generally at **482** of the second portion **412** to form the sub-fiber **360**. The resultant sub-fiber **360** is shown in FIG. 3. Between the first-fractional end **451** and a second-fractional end **452** of the sub-fiber **360** is a non-fractional segment **413** of the sub-fiber **360**.

When the 1:3-split fiber **350** is used as a node **100** (FIG. 1) in a passive optical hub, four (4) nodes **100** are required to form the passive optical hub. When a 1:4-split fiber is used as a node in a passive optical hub, five nodes are required to form the passive optical hub. In this latter case, N equals four (4), and a plastic-optical fiber **170** is shaved into 4 equal sub-fibers that are a one/quarter segments of the plastic-optical fiber and look like wedges that subtend an angle of approximately 90 degrees. Alternately, the four sub-fibers forming a 1:4-split fiber can include the first-fractional ends **451-1**, **451-2**, **451-3**, and **451-4** with unequal relative percentages of cross-sections.

In one implementation of this embodiment, the plastic-optical fiber **170**, from which the sub-fiber **360** is formed, has a diameter of 1 mm. In another implementation of this embodiment, the plastic-optical fiber **170** has a diameter of 2 mm. In this latter embodiment, a beam expander is inserted between the sub-fibers forming a 1:N-split fiber and the plastic-optical fiber of a POH as described in detail below.

FIG. 4 is a flow diagram of an embodiment of a method **400** of forming an (N+1)-way passive optical hub (POH) for use in a plastic optical fiber network. The fabrication of a 4-way POH from four nodes (FIG. 1) is now described with reference to method **400** of FIG. 4 and FIGS. 5-8. FIG. 5 illustrates three first-fractional ends **451(1-3)** of three respective sub-fibers **360(1-3)** fused to form a fused-fractional end **310** in accordance with the present invention. The three sub-fibers **360(1-3)** with three fused first-fractional ends **451(1-3)** form a 1:3 split fiber **47**. FIG. 6 illustrates a partially formed plastic optical hub **48** in which two fused-fractional ends **310-1** and **310-2** of two respective 1:3 split fibers (such as, 1:3 split fiber **47** shown in FIG. 5) are fused to two respective first ends **176** of plastic-optical fibers **175-1** and **175-2** in accordance with the present invention. In the partially formed plastic optical hub **48**, the two fused-fractional ends **310-1** and **310-2** of two respective 1:3 split fibers (such as, 1:3 split fiber **47** shown in FIG. 5) are fused to two respective plastic-optical fibers **175-1** and **175-2**. FIG. 7 illustrates a partially formed plastic optical hub **49** in which three fused-fractional ends **310-1**, **310-2**, and **310-3** are fused to three respective first ends **176** of plastic-optical fibers **175-1**, **175-2**, and **175-3** in accordance with the present invention. In the partially formed plastic optical hub **49**, the three fused-fractional ends **310-1**, **310-2**, and **310-3** of three respective 1:3 split fibers (such as, 1:3 split fiber **47** shown in FIG. 5) are fused to three respective first ends **176** of

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plastic-optical fibers **175-1**, **175-2**, and **175-3**. FIG. 8 illustrates the plastic optical hub **50** in accordance with the present invention. In the plastic optical hub **50**, the four fused-fractional ends **310(1-4)** of four respective 1:3 split fibers (such as, 1:3 split fiber **47** shown in FIG. 5) are fused to four

respective plastic-optical fibers **175(1-4)**.  
At block **402**,  $N$  first-fractional ends of  $N$  of  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  sub-fibers to form a fused-fractional end. For  $N=3$ , as FIG. 5 illustrates, three first-fractional ends **451(1-3)** of three respective sub-fibers **360(1-3)** are fused to form a fused-fractional end **310** in accordance with the present invention. The fusing of the first-fractional ends **451(1-3)** is done by ultrasonically welding, transparent latic plastic welding, or plastic solvent welding the three first-fractional ends **451(1-3)** as they are held together in an appropriately designed chuck. One skilled in the art of ultrasonically welding, transparent latic plastic welding, or plastic solvent welding will understand how to design the appropriate chuck for the fusing. Ultrasonic welding is a reliable, simple, and low cost approach to fusing the fractional-ends of the sub-fibers to each other. However, anyone of several techniques to bond the sub-fibers to other sub-fibers, including but not limited to transparent latic plastic welding, or plastic solvent welding can be used. Any future developed technique to bond (fuse) plastic can be used to form the 1: $N$ -split fibers **350**, the node **100**, and the passive optical hubs described herein.

At block **404**, the fused-fractional end **310** is fused to one of a first end of a first plastic-optical fiber or a large end of a first beam expander. When the fused-fractional end **310** is fused to the first end **176** of the plastic-optical fiber **175-1** (FIG. 6) (or a large end of a first beam expander as described below in detail), the node **101** (FIG. 6) (or node **106** shown below with reference to FIG. 10) is formed. In this manner, three first-fractional ends of three of the six sub-fibers are fused to form the fused-fractional end **310-1** of a 1:3 split fiber **47** (FIG. 5) that is fused to the first end **176** of the first plastic-optical fiber **175-1** to form the node **101** (FIG. 6).

In one implementation of this embodiment, the fusing of the first-fractional ends **451(1-3)** to each other (block **402**) and to the first end **176** of the plastic-optical fiber **175** (block **404**) is done simultaneously by ultrasonically welding, transparent latic plastic welding, or plastic solvent welding the three first-fractional ends **451(1-3)** and first end **176** of the plastic-optical fiber **175** as they are held together in an appropriately designed chuck. In one implementation of this embodiment, the plastic-optical fiber **175** has a diameter of 1 mm.

At block **406**, a second-fractional end of a first-sub-fiber of the  $N$  sub-fibers is to one of a first end of a second plastic-optical fiber or a large end of a second beam expander. As shown in FIG. 6, the second-fractional end **452-1** of the first-sub-fiber **360-1** of the  $N$  sub-fibers **360(1-3)** is fused to the first end **176** (FIG. 1) of a second plastic-optical fiber **175-2**.

As is also shown in FIG. 6, a first-fractional end **451-4** of a fourth-sub-fiber **360-4** of the six sub-fibers **360(1-6)** is fused to the first end **176** (FIG. 1) of the second plastic-optical fiber **175-2**. As is also shown in FIG. 6, a first-fractional end **451-5** (not visible in FIG. 6 since it is behind the second-fractional end **452-1** and first-fractional end **451-4**) of a fifth-sub-fiber **360-5** of the six sub-fibers **360(1-6)** is fused to the first end **176** (FIG. 1) of the second plastic-optical fiber **175-2**. Thus, three fractional fiber ends are fused to the second plastic-optical fiber **175** to form a second node **102**. In one implementation of this embodiment, the second-fractional end **452-1** of the first-sub-fiber **360-1**, the first-fractional end **451-4** of the fourth-sub-fiber **360-4**, and the first-fractional

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end **451-5** of the fifth-sub-fiber **360-5** are simultaneously fused to the first end **176** of the second plastic-optical fiber **175-2** to form the second node **102**.

At block **408**, a second-fractional end of an  $N^{th}$ -sub-fiber of the  $N$  sub-fibers is fused to a first end of an  $(N+1)^{th}$  plastic-optical fiber or a large end of an  $(N+1)^{th}$  beam expander. As shown in FIG. 7, the second-fractional end **452-2** of the second-sub-fiber **360-2** is fused to a first end **176** (FIG. 1) of a third plastic-optical fiber **175-3**.

As is also shown in FIG. 7, a second-fractional end **452-4** of the fourth-sub-fiber **360-4** of the six sub-fibers **360(1-6)** is fused to the first end **176** (FIG. 1) of the third plastic-optical fiber **175-3**, and the first-fractional end **451-6** of a sixth-sub-fiber **360-6** of the six sub-fibers **360(1-6)** is fused to the first end **176** of the third plastic-optical fiber **175-3**. Thus, three fractional fiber ends (**452-2**, **452-4**, and **451-6**) are fused to the third plastic-optical fiber **175-3** to form a third node **103**. In one implementation of this embodiment, the second-fractional end **452-4** of the fourth-sub-fiber **360-4**, the first-fractional end **451-6** of the sixth-sub-fiber **360-6**, and the second-fractional end **452-2** of the second-sub-fiber **360-2** are simultaneously fused to the first end **176** of the third plastic-optical fiber **175-3** to form the third node **103**.

As shown in FIG. 7, the second-fractional end **452-3** of the third-sub-fiber **360-3**, the second-fractional end **452-5** of the fifth-sub-fiber **360-5**, and the second-fractional end **452-6** of the sixth-sub-fiber **360-6** are bundled together. These fractional ends **452-3**, **452-5**, and **452-6** are fused to form a fused-fractional end **310-4**.

As shown in FIG. 8, the second-fractional end **452-3** of the third-sub-fiber **360-3**, the second-fractional end **452-5** of the fifth-sub-fiber **360-5**, and the second-fractional end **452-6** of the sixth-sub-fiber **360-6** are fused to the first end **176** (FIG. 1) of the fourth plastic-optical fiber **175** to form the fourth node **104**. In this manner, the four optical nodes **101**, **102**, **103**, and **104** are fused to form a low loss passive optical hub **50**. The fusing of multiple joints can be made simultaneously by an appropriately configured welding chuck.

In one implementation of this embodiment, the second-fractional end **452-1**, the first-fractional end **451-4**, and the first-fractional end **451-5** are simultaneously fused to the first end **176** of the second plastic-optical fiber **175-2**. In another implementation of this embodiment, the second-fractional end **452-1**, the first-fractional end **451-4**, and the first-fractional end **451-5** are simultaneously fused to each other and then the second fused-fractional end **310-2** is fused to the first end **176** of the second plastic-optical fiber **175-2**.

In yet another implementation of this embodiment, the second-fractional end **452-4**, the second-fractional end **452-2**, and the first-fractional end **451-6** are simultaneously fused to the first end **176** of the third plastic-optical fiber **175-3**. In another implementation of this embodiment, the second-fractional end **452-4**, the second-fractional end **452-2**, and the first-fractional end **451-6** are simultaneously fused to each other and then the third fused-fractional end **310-3** is fused to the first end **176** of the third plastic-optical fiber **175-3**.

In yet another implementation of this embodiment, the second-fractional end **452-3**, the second-fractional end **452-5**, and the second-fractional end **452-6** are simultaneously fused to the first end **176** of the fourth plastic-optical fiber **175-4**. In another implementation of this embodiment, the second-fractional end **452-3**, the second-fractional end **452-5**, and the second-fractional end **452-6** are simultaneously fused to each other and then the fourth fused-fractional end **310-4** is fused to the first end **176** of the fourth plastic-optical fiber **175-4**.

One skilled in the art understands how to form a 5-way POH with five plastic-optical fibers, and ten sub-fibers based on the above description of how to form a 4-way POH with four plastic-optical fibers **175(1-4)** and six sub-fibers **360(1-6)**.

The fused peer-to-peer configuration of a POH described above maintains the highest geometry efficiency possible. There are no mirrors or air gaps as in the current reflectors. Thus, the low cost passive optical hub described herein eliminates return loss, and reflectivity loss and eliminates a long return loop thereby reducing device dispersion loss.

FIG. 9 shows an exemplary beam expander **178** in accordance with the present invention. FIG. 10 illustrates an embodiment of a node **201** for a low loss passive optical hub including the beam expander **178** of FIG. 9 in accordance with the present invention. As shown in FIG. 9, the beam expander **178** has a large end **179** with a first diameter  $D_1$  and a small end **178** with a second diameter  $D_2$ , where the second diameter  $D_2$  is less than the first diameter  $D_1$ . The beam expander **178** is used to optically couple plastic optical fibers having different diameters.

To improve splitting precision and uniformity, a plastic-optical fiber with a relatively large diameter (e.g., greater than 1 mm) is used to form the 1:N-split fiber. A plastic-optical fiber **175**, which typically has a diameter of about 1 mm, can be optically coupled to 1:N-split fiber formed from a larger diameter plastic-optical fiber **170** (FIGS. 2A and 2C) by interfacing the beam expander **178** between the fused-fractional end **310** of the 1:N-split fiber formed from the larger diameter optical fiber **170** and the smaller diameter plastic-optical fiber **175**. The beam expander **178** can be formed by injection molding, which is a reliable, inexpensive process.

As used herein, the beam expander **178** optically couples a first end **176** of the plastic optical fiber **175** (FIG. 1) with the second diameter  $D_2$  (smaller diameter) to form an embodiment of a 1:N-split fiber (e.g., 1:3-split fiber **350** shown in FIG. 1) with the first diameter  $D_1$  (larger diameter). In one implementation of this embodiment, the first diameter is 2 mm and the second diameter is 1 mm. Typically a plastic-optical fiber has a diameter of 1 mm.

The first end **176** of the plastic-optical fiber **175** is fused to the small end **180** of the beam expander **178** and the fused-fractional end **310** of the 1:N-split fiber **350** is fused to the large end **179** of the beam expander **178**. In this manner, the first end **176** of the plastic-optical fiber **175** is optically coupled to the fused-fractional end **310** of the 1:N-split fiber **350** via the beam expander **178**. In one implementation of this embodiment, the small end **180** of the beam expander is ultrasonically welded to the plastic-optical fiber **175** with the smaller diameter (e.g., a diameter of 1 mm).

FIG. 11 illustrates an embodiment of a low loss passive optical hub **51** including the beam expander **178** of FIG. 9 in accordance with the present invention. The POH **51** differs from the POH **50** of FIG. 8 in that a first beam expander **178-1** is in the first node **201**, a second beam expander **178-2** is in the second node **203**, a third beam expander **178-3** is in the third node **203**, and a fourth beam expander **178-4** is in the fourth node **201**. The large ends **179** of the beam expanders **178(1-4)** are each fused to the respective fused-fractional ends **310(1-4)** and the small ends **180** of the of the beam expanders **178(1-4)** are each fused to the respective plastic-optical fibers **175(1-3)**. In this embodiment, the diameter of the fused-fractional ends **310(1-4)** is equal to the diameter of the large ends **179** of the respective beam expanders **178(1-4)**.

A plurality of the embodiments of the POHs described herein can be implemented in a low cost, low loss optical fiber bus network. Such an optical fiber bus network would include

the low cost plastic optical fibers to link the POH **50** (FIG. 8) and/or the POH **51** (FIG. 11) to each other as required by the application. This type of optical fiber bus network would weigh less than a copper bus network and would, therefore be useful on an aircraft since it is desirable to reduce the weight on aircraft.

## EXAMPLE EMBODIMENTS

Example 1 includes a node for a low loss passive optical hub, comprising: a 1:N-split fiber having a fused-fractional end and N second-fractional ends, the 1:N-split fiber formed from N sub-fibers, the N sub-fibers each having a first-fractional end and a second-fractional end, wherein the N first-fractional ends are fused to form the fused-fractional end; and a plastic-optical fiber having a first end and a second end, the first end of the plastic-optical fiber optically coupled to the fused-fractional end of the 1:N-split fiber.

Example 2 includes the node of Example 1, wherein N equals 3, wherein the 1:N-split fiber is a 1:3-split fiber formed from three sub-fibers, and wherein three first-fractional ends are fused to form the fused-fractional end.

Example 3 includes the node of any of Examples 1-2, wherein at least one of the N sub-fibers includes a non-fractional segment.

Example 4 includes the node of any of Examples 1-3, further comprising: a beam expander having a large end and a small end, the large end having a larger diameter than the small end, wherein the first end of the plastic-optical fiber is fused to the small end, and wherein the fused-fractional end of the 1:N-split fiber is fused to the large end so the first end of the plastic-optical fiber is optically coupled to the fused-fractional end of the 1:N-split fiber via the beam expander.

Example 5 includes the node of any of Examples 1-3, wherein the first end of the plastic-optical fiber is fused to the fused-fractional end of the 1:N-split fiber.

Example 6 includes an (N+1)-way passive optical hub, comprising: (N+1) plastic-optical fibers each having a first end and a second end; and  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  sub-fibers having respective  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  first-fractional ends and  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  second-fractional ends, wherein N first-fractional ends of N of the  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  sub-fibers are fused together to form a fused-fractional end of a 1:N-split fiber, wherein the fused-fractional end is fused to one of a first end of a first plastic-optical fiber or a large end of a first beam expander to form a first node, wherein a second-fractional end of a first-sub-fiber of the N sub-fibers is fused to one of a first end of a second plastic-optical fiber or a large end of a second beam expander, and wherein a second-fractional end of an  $N^{th}$ -sub-fiber of the N sub-fibers is fused to a first end of an  $(N+1)^{th}$  plastic-optical fiber or a large end of an  $(N+1)^{th}$  beam expander.

Example 7 includes the (N+1)-way passive optical hub of Example 6, wherein the fused-fractional end is fused to the large end of the first beam expander, wherein the first end of the first plastic-optical fiber is fused to a small end of the first beam expander, wherein the second-fractional end of the first-sub-fiber of the N sub-fibers is fused to the large end of the second beam expander, wherein the first end of the second plastic-optical fiber is fused to a small end of the second beam expander, wherein the second-fractional end of the  $N^{th}$ -sub-fiber of the N sub-fibers is fused to the large end of the  $(N+1)^{th}$  beam expander, and wherein the first end of the  $(N+1)^{th}$  plastic-optical fiber is fused to a small end of the  $(N+1)^{th}$  beam expander.

Example 8 includes the  $(N+1)$ -way passive optical hub of any of Examples 6-7, wherein  $N$  equals 3, wherein the  $(N+1)$ -way passive optical hub is a 4-way passive optical hub comprising: four plastic-optical fibers each having the first end and the second end; and six sub-fibers having respective six first-fractional ends and six second-fractional ends, wherein three first-fractional ends of three of the six sub-fibers are fused together to form the fused-fractional end that is fused the first end of the first plastic-optical fiber to form the first node, wherein the second-fractional end of the first-sub-fiber of the three of the six sub-fibers is fused to the first end of the second plastic-optical fiber, wherein the second-fractional end of a second-sub-fiber of the three of the six sub-fibers is fused to the first end of a third plastic-optical fiber, and wherein the second-fractional end of a third-sub-fiber of the three of the six sub-fibers is fused to the first end of a fourth plastic-optical fiber.

Example 9 includes the  $(N+1)$ -way passive optical hub of Example 8, wherein the first-fractional end of a fourth-sub-fiber of the six sub-fibers is fused to the first end of the second plastic-optical fiber, and wherein the second-fractional end of the fourth-sub-fiber of the six sub-fibers is fused to the first end of the third plastic-optical fiber.

Example 10 includes the  $(N+1)$ -way passive optical hub of Example 9, wherein the first-fractional end of a fifth-sub-fiber of the six sub-fibers is fused to the first end of the second plastic-optical fiber, and wherein the second-fractional end of the fifth-sub-fiber of the six sub-fibers is fused to the first end of the fourth plastic-optical fiber.

Example 11 includes the  $(N+1)$ -way passive optical hub of Example 10, wherein the first-fractional end of a sixth-sub-fiber of the six sub-fibers is fused to the first end of the third plastic-optical fiber, and wherein the second-fractional end of the sixth-sub-fiber of the six sub-fibers is fused to the first end of the fourth plastic-optical fiber.

Example 12 includes the  $(N+1)$ -way passive optical hub of any of Examples 6-7, wherein  $N$  equals 3, wherein the  $(N+1)$ -way passive optical hub is a 4-way passive optical hub comprising: four plastic-optical fibers each having the first end and the second end; four beam expanders each having a small end and the large end; and six sub-fibers having, respectively, six first-fractional ends and six second-fractional ends, wherein three first-fractional ends of three of the six sub-fibers are fused together to form the fused-fractional end that is fused to the large end of the first beam expander to form the first node, wherein the second-fractional end of the first-sub-fiber of the three of the six sub-fibers is fused to the large end of the second beam expander, wherein the second-fractional end of a second-sub-fiber of the three of the six sub-fibers is fused to the large end of a third beam expander, and wherein the second-fractional end of a third-sub-fiber of the three of the six sub-fibers is fused to the large end of a fourth beam expander.

Example 13 includes the  $(N+1)$ -way passive optical hub of Example 12, wherein the first-fractional end of a fourth-sub-fiber of the six sub-fibers is fused to the large end of the second beam expander, wherein the second-fractional end of the fourth-sub-fiber of the six sub-fibers is fused to the large end of the third beam expander, wherein the first-fractional end of a fifth-sub-fiber of the six sub-fibers is fused to the large end of the second beam expander, wherein the second-fractional end of the fifth-sub-fiber of the six sub-fibers is fused to the large end of the fourth beam expander, wherein the first-fractional end of a sixth-sub-fiber of the six sub-fibers is fused to the large end of the third beam expander, and

wherein the second-fractional end of the sixth-sub-fiber of the six sub-fibers is fused to the large end of the fourth beam expander.

Example 14 includes the  $(N+1)$ -way passive optical hub of any of Examples 12-13, wherein the first end of the first plastic-optical fiber is fused to the small end of the first beam expander, wherein the first end of the second plastic-optical fiber is fused to the small end of the second beam expander, wherein the first end of the third plastic-optical fiber is fused to the small end of the third beam expander, and wherein the first end of the fourth plastic-optical fiber is fused to the small end of the fourth beam expander.

Example 15 includes a method of forming an  $(N+1)$ -way passive optical hub for use in a plastic optical fiber network, the method comprising: fusing  $N$  first-fractional ends of  $N$  of  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  sub-fibers to form a fused-fractional end; fusing the fused-fractional end to one of a first end of a first plastic-optical fiber or a large end of a first beam expander; fusing a second-fractional end of a first-sub-fiber of the  $N$  sub-fibers to one of a first end of a second plastic-optical fiber or a large end of a second beam expander; fusing a second-fractional end of an  $N^{th}$ -sub-fiber of the  $N$  sub-fibers to a first end of an  $(N+1)^{th}$  plastic-optical fiber or a large end of an  $(N+1)^{th}$  beam expander.

Example 16 includes the method of Example 15, wherein fusing the fused-fractional end to one of the first end of the first plastic-optical fiber or the large end of the first beam expander comprises fusing the fused-fractional end to the large end of the first beam expander, wherein fusing the second-fractional end of the first-sub-fiber of the  $N$  sub-fibers to one of the first end of the second plastic-optical fiber or the large end of the second beam expander comprises fusing the second-fractional end of the first-sub-fiber of the  $N$  sub-fibers to the large end of the second beam expander, and wherein fusing the second-fractional end of the  $N^{th}$ -sub-fiber of the  $N$  sub-fibers to the first end of the  $(N+1)^{th}$  plastic-optical fiber or the large end of the  $(N+1)^{th}$  beam expander comprises fusing the second-fractional end of the  $N^{th}$ -sub-fiber of the  $N$  sub-fibers to the large end of the  $(N+1)^{th}$  beam expander, the method further comprising: fusing the first end of the first plastic-optical fiber to a small end of the first beam expander; fusing the first end of the second plastic-optical fiber to a small end of the second beam expander; and fusing the first end of the  $(N+1)^{th}$  plastic-optical fiber to a small end of the  $(N+1)^{th}$  beam expander.

Example 17 includes the method of any of Examples 15-16, wherein  $N$  equals 3 and the  $(N+1)$ -way passive optical hub is a 4-way passive optical hub including: four plastic-optical fibers having a first end and a second end; and six sub-fibers having, respectively, six first-fractional ends and six second-fractional ends, wherein fusing the  $N$  first-fractional ends of the  $N$  of  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  sub-fibers to form the fused-fractional end comprises fusing three first-fractional ends of six sub-fibers to form the fused-fractional end, wherein fusing the fused-fractional end to one of the first end of the first plastic-optical fiber or the large end of the first beam expander comprises fusing the fused-fractional end to the first end of the first plastic-optical fiber, wherein fusing the second-fractional end of the first-sub-fiber of the  $N$  sub-fibers to one of the first end of the second plastic-optical fiber or the large end of the second beam expander comprises fusing the second-fractional end of the first-sub-fiber of the three of the six sub-fibers to the first end of the second plastic-optical fiber, and wherein fusing the second-fractional end of the  $N^{th}$ -sub-fiber of the  $N$  sub-fibers to one of the first end of the  $(N+1)^{th}$  plastic-optical fiber or the large end of the  $(N+1)^{th}$  beam expander comprises fusing the

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second-fractional end of a third-sub-fiber of the three of the six sub-fibers to the first end of a fourth plastic-optical fiber, the method further comprising: fusing the second-fractional end of a second-sub-fiber of the three of the six sub-fibers to the first end of a third plastic-optical fiber; fusing the first-fractional end of a fourth-sub-fiber of the six sub-fibers to the first end of the second plastic-optical fiber; fusing the second-fractional end of the fourth-sub-fiber of the six sub-fibers to the first end of the third plastic-optical fiber; fusing the first-fractional end of a fifth-sub-fiber of the six sub-fibers to the first end of the second plastic-optical fiber; fusing the second-fractional end of the fifth-sub-fiber of the six sub-fibers to the first end of the fourth plastic-optical fiber; fusing the first-fractional end of a sixth-sub-fiber of the six sub-fibers to the first end of the third plastic-optical fiber; and fusing the second-fractional end of the sixth-sub-fiber of the six sub-fibers to the first end of the fourth plastic-optical fiber.

Example 18 includes the method of any of Examples 15-16, wherein N equals 3 and the (N+1)-way passive optical hub is a 4-way passive optical hub including: four plastic-optical fibers each having the first end and the second end; four beam expanders each having a large end and a small end; and six sub-fibers having, respectively, six first-fractional ends and six second-fractional ends, wherein fusing the N first-fractional ends of the N of  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  sub-fibers to form the fused-fractional end comprises fusing three first-fractional ends of six sub-fibers to form the fused-fractional end, wherein fusing the fused-fractional end to one of the first end of the first plastic-optical fiber or the large end of the first beam expander comprises fusing the fused-fractional end to the large end of the first beam expander, wherein fusing the second-fractional end of the first-sub-fiber of the N sub-fibers to one of the first end of the second plastic-optical fiber or the large end of the second beam expander comprises fusing the second-fractional end of the first-sub-fiber of the three of the six sub-fibers to the large end of the second beam expander, and wherein fusing the second-fractional end of the  $N^{th}$ -sub-fiber of the N sub-fibers to one of the first end of the  $(N+1)^{th}$  plastic-optical fiber or the large end of the  $(N+1)^{th}$  beam expander comprises fusing the second-fractional end of a third-sub-fiber of the three of the six sub-fibers to the large end of a fourth beam expander, the method further comprising: fusing the second-fractional end of a second-sub-fiber of the three of the six sub-fibers to a large end of a third beam expander; fusing the first-fractional end of a fourth-sub-fiber of the six sub-fibers to the large end of the second beam expander; fusing the second-fractional end of the fourth-sub-fiber of the six sub-fibers to the large end of the third beam expander; fusing the first-fractional end of a fifth-sub-fiber of the six sub-fibers to the large end of the second beam expander; fusing the second-fractional end of the fifth-sub-fiber of the six sub-fibers to the large end of the fourth beam expander; fusing the first-fractional end of a sixth-sub-fiber of the six sub-fibers to the large end of the third beam expander; and fusing the second-fractional end of the sixth-sub-fiber of the six sub-fibers to the large end of the fourth beam expander.

Example 19 includes the method of any of Examples 15-18, further comprising: shaving at least a first portion of  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  plastic-optical fibers to form the  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  sub-fibers shaving at least a second portion of  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  plastic-optical fibers to form the  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  sub-fibers.

Example 20 includes the method of Example 19, further comprising: cutting midsections of the  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  first portions; and cutting midsections of the

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$N+(N-1)+(N-2)+\dots+[N-(N-1)]$  second portions. Although specific embodiments have been illustrated and described herein, it will be appreciated by those of ordinary skill in the art that any arrangement, which is calculated to achieve the same purpose, may be substituted for the specific embodiment shown. This application is intended to cover any adaptations or variations of the present invention. Therefore, it is manifestly intended that this invention be limited only by the claims and the equivalents thereof.

What is claimed is:

1. A node for a low loss passive optical hub, comprising:
  - a 1:N-split fiber having a fused-fractional end and N second-fractional ends, the 1:N-split fiber formed from N sub-fibers formed from plastic-optical fibers, the N sub-fibers each having a first-fractional end and a second-fractional end, wherein the first-fractional ends and second-fractional ends have respective V-shaped cross-sectional shapes subtending a desired angle, and wherein the N first-fractional ends are fused to form the fused-fractional end; and
  - a plastic-optical fiber having a first end and a second end, the first end of the plastic-optical fiber optically coupled to the fused-fractional end of the 1:N-split fiber.
2. The node of claim 1, wherein N equals 3, wherein the 1:N-split fiber is a 1:3-split fiber formed from three sub-fibers, and wherein three first-fractional ends are fused to form the fused-fractional end.
3. The node of claim 1, wherein at least one of the N sub-fibers includes a non-fractional segment.
4. The node of claim 1, further comprising:
  - a beam expander having a large end and a small end, the large end having a larger diameter than the small end, wherein the first end of the plastic-optical fiber is fused to the small end, and wherein the fused-fractional end of the 1:N-split fiber is fused to the large end so the first end of the plastic-optical fiber is optically coupled to the fused-fractional end of the 1:N-split fiber via the beam expander.
5. The node of claim 1, wherein the first end of the plastic-optical fiber is fused to the fused-fractional end of the 1:N-split fiber.
6. An (N+1)-way passive optical hub, comprising:
  - (N+1) plastic-optical fibers each having a first end and a second end; and
  - $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  sub-fibers formed from plastic-optical fibers and having respective  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  first-fractional ends and  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  second-fractional ends, wherein the first-fractional ends and second-fractional ends have respective V-shaped cross-sectional shapes subtending respective desired angles, wherein N first-fractional ends of N of the  $N+(N-1)+(N-2)+\dots+[N-(N-1)]$  sub-fibers are fused together to form a fused-fractional end of a 1:N-split fiber, wherein the fused-fractional end is fused to one of a first end of a first plastic-optical fiber or a large end of a first beam expander to form a first node, wherein a second-fractional end of a first-sub-fiber of the N sub-fibers is fused to one of a first end of a second plastic-optical fiber or a large end of a second beam expander, and wherein a second-fractional end of an  $N^{th}$ -sub-fiber of the N sub-fibers is fused to a first end of an  $(N+1)^{th}$  plastic-optical fiber or a large end of an  $(N+1)^{th}$  beam expander.
7. The (N+1)-way passive optical hub of claim 6, wherein the fused-fractional end is fused to the large end of the first beam expander,

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wherein the first end of the first plastic-optical fiber is fused to a small end of the first beam expander,  
 wherein the second-fractional end of the first-sub-fiber of the N sub-fibers is fused to the large end of the second beam expander,  
 wherein the first end of the second plastic-optical fiber is fused to a small end of the second beam expander,  
 wherein the second-fractional end of the N<sup>th</sup>-sub-fiber of the N sub-fibers is fused to the large end of the (N+1)<sup>th</sup> beam expander, and  
 wherein the first end of the (N+1)<sup>th</sup> plastic-optical fiber is fused to a small end of the (N+1)<sup>th</sup> beam expander.

8. The (N+1)-way passive optical hub of claim 6, wherein N equals 3, wherein the (N+1)-way passive optical hub is a 4-way passive optical hub comprising:  
 four plastic-optical fibers each having the first end and the second end; and  
 six sub-fibers having respective six first-fractional ends and six second-fractional ends,  
 wherein three first-fractional ends of three of the six sub-fibers are fused together to form the fused-fractional end that is fused the first end of the first plastic-optical fiber to form the first node,  
 wherein the second-fractional end of the first-sub-fiber of the three of the six sub-fibers is fused to the first end of the second plastic-optical fiber,  
 wherein the second-fractional end of a second-sub-fiber of the three of the six sub-fibers is fused to the first end of a third plastic-optical fiber, and  
 wherein the second-fractional end of a third-sub-fiber of the three of the six sub-fibers is fused to the first end of a fourth plastic-optical fiber.

9. The (N+1)-way passive optical hub of claim 8,  
 wherein the first-fractional end of a fourth-sub-fiber of the six sub-fibers is fused to the first end of the second plastic-optical fiber, and  
 wherein the second-fractional end of the fourth-sub-fiber of the six sub-fibers is fused to the first end of the third plastic-optical fiber.

10. The (N+1)-way passive optical hub of claim 9,  
 wherein the first-fractional end of a fifth-sub-fiber of the six sub-fibers is fused to the first end of the second plastic-optical fiber, and  
 wherein the second-fractional end of the fifth-sub-fiber of the six sub-fibers is fused to the first end of the fourth plastic-optical fiber.

11. The (N+1)-way passive optical hub of claim 10,  
 wherein the first-fractional end of a sixth-sub-fiber of the six sub-fibers is fused to the first end of the third plastic-optical fiber, and  
 wherein the second-fractional end of the sixth-sub-fiber of the six sub-fibers is fused to the first end of the fourth plastic-optical fiber.

## 14

12. The (N+1)-way passive optical hub of claim 6, wherein N equals 3, wherein the (N+1)-way passive optical hub is a 4-way passive optical hub comprising:  
 four plastic-optical fibers each having the first end and the second end;  
 four beam expanders each having a small end and the large end; and  
 six sub-fibers having, respectively, six first-fractional ends and six second-fractional ends,  
 wherein three first-fractional ends of three of the six sub-fibers are fused together to form the fused-fractional end that is fused to the large end of the first beam expander to form the first node,  
 wherein the second-fractional end of the first-sub-fiber of the three of the six sub-fibers is fused to the large end of the second beam expander,  
 wherein the second-fractional end of a second-sub-fiber of the three of the six sub-fibers is fused to the large end of a third beam expander, and  
 wherein the second-fractional end of a third-sub-fiber of the three of the six sub-fibers is fused to the large end of a fourth beam expander.

13. The (N+1)-way passive optical hub of claim 12,  
 wherein the first-fractional end of a fourth-sub-fiber of the six sub-fibers is fused to the large end of the second beam expander,  
 wherein the second-fractional end of the fourth-sub-fiber of the six sub-fibers is fused to the large end of the third beam expander,  
 wherein the first-fractional end of a fifth-sub-fiber of the six sub-fibers is fused to the large end of the second beam expander,  
 wherein the second-fractional end of the fifth-sub-fiber of the six sub-fibers is fused to the large end of the fourth beam expander,  
 wherein the first-fractional end of a sixth-sub-fiber of the six sub-fibers is fused to the large end of the third beam expander, and  
 wherein the second-fractional end of the sixth-sub-fiber of the six sub-fibers is fused to the large end of the fourth beam expander.

14. The (N+1)-way passive optical hub of claim 12,  
 wherein the first end of the first plastic-optical fiber is fused to the small end of the first beam expander,  
 wherein the first end of the second plastic-optical fiber is fused to the small end of the second beam expander,  
 wherein the first end of the third plastic-optical fiber is fused to the small end of the third beam expander, and  
 wherein the first end of the fourth plastic-optical fiber is fused to the small end of the fourth beam expander.

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